



**Product Data Sheet &
General Processing Conditions**

**RTP 2099 X 121249 B
Bio-Based Polylactic Acid (PLA)
Standard Nucleator
Glass Fiber
78% Renewable Resource Content**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	20 %	20 %	
Specific Gravity	1.39	1.39	D 792

MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	0.9 ft-lbs/in	48 J/m	D 256
unnotched 1/8 in (3.2 mm) section	6.0 ft-lbs/in	320 J/m	D 4812
Tensile Strength	14000 psi	97 MPa	D 638
Tensile Elongation	1.5 %	1.5 %	D 638
Tensile Modulus	1.20 x 10 ⁶ psi	8274 MPa	D 638
Flexural Strength	17000 psi	117 MPa	D 790
Flexural Modulus	1.25 x 10 ⁶ psi	8619 MPa	D 790

THERMAL

Deflection Temperature			
@ 264 psi (1820 kPa)	298 °F	148 °C	D 648
@ 66 psi (455 kPa)	305 °F	152 °C	D 648

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	8000 - 15000 psi	55 - 103 MPa
Melt Temperature	340 - 380 °F	171 - 193 °C
Mold Temperature	180 - 220 °F	82 - 104 °C
Drying	2 - 6 hrs @ 130 °F	2 - 6 hrs @ 54 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-40 °F	-40 °C